X-CF Pro

This guide only applies to X-CF Pro 3D printer

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X-CF Pro

Caution

1. Do not remove the rubber sleeve wrapped around the normal nozzle assembly.

2. When print with PLA filament,please Please take down the top cover and open the front door, keep air flow for getting better printing quality.

Warning

1. High Temperature! The extruder and build bed generates high temperature during the printing. Please do not reach inside of the printer during operation. After printing finished,wait for model to cool down before remove them from the magnetic bed sticker.

2. Loose clothes, jewelry and long hair can be caught in moving parts. Please keep away from them.

Slicer

The electronic version of user manual is in the USB flash drive that came with printer.

Customer Service Support:

Thank you for purchasing our QIDI Technology 3d printer.

If you are experiencing any problems with the printer,please feel free to contact us!

We will reply to you within **12 hours.**

If not,our company will offer you 2 nozzle and 2 pieces of blue platform sticker for free as compensation.

Contact:

E-mail: may@qd3dprinter.com
lisa@qd3dprinter.com
Skype ID : vivi19871987

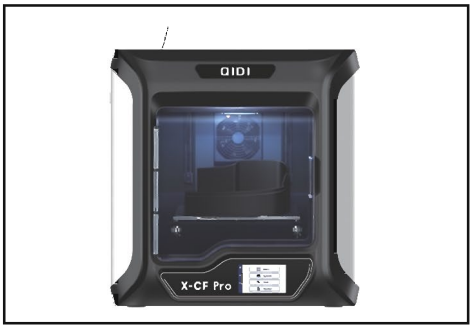
If you have any suggestion or complaints,please contact with this E-mail address:

CEO:Diqiang Xue (Reply within 24 hours.)
E-mail:616038502@qq.com

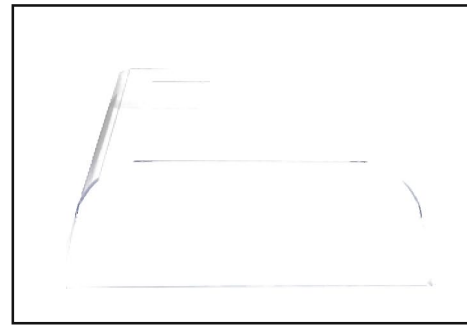
Thank you and regards,
QiDi Technology Co.,Ltd.

Due to the time difference, if we could not reply in time, please understand!

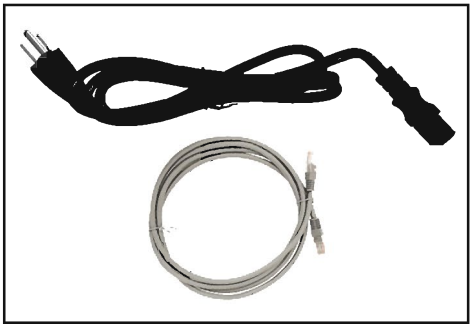
Kit Contents



3D Printer×1



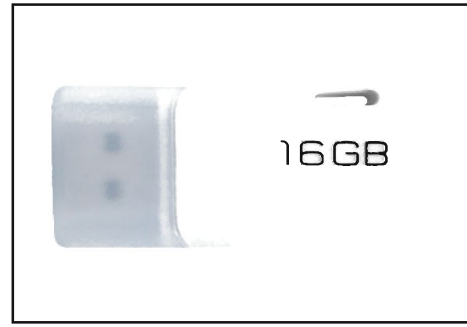
Transparent top cover×1



Power Cable&
Lan Cable ×1

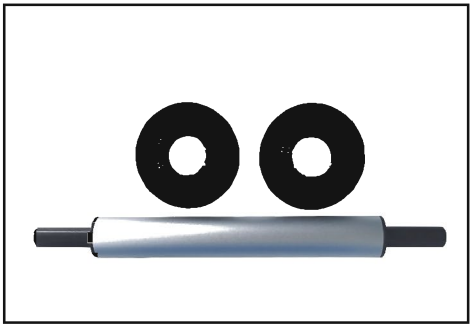
Normal extruder
assembly ×1

User Guide×1

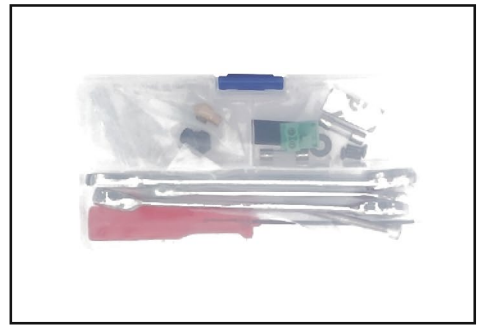


USB Pen Drive ×1

Kit Contents

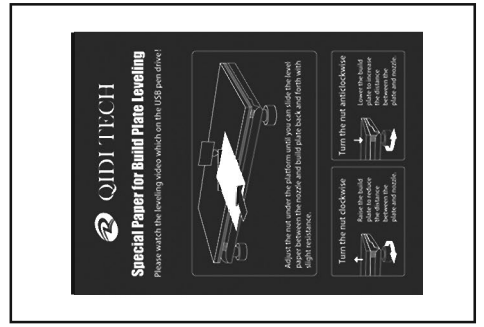


Filament Holder & Gasket



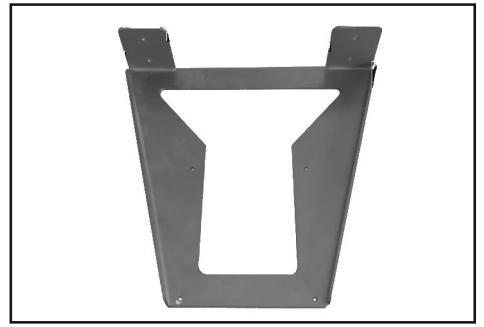
Spare Part Box ×1

Filament×1


QIDI TECH
Special Paper for Build Plate Leveling
Please watch the leveling video which on the USB port drive!
Turn the nut anticlockwise
Turn the nut clockwise

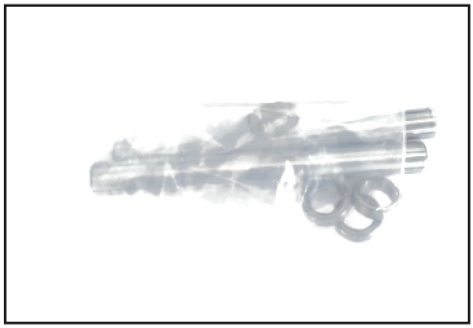
Leveling Paper×1

Dry box & sealing tape×1



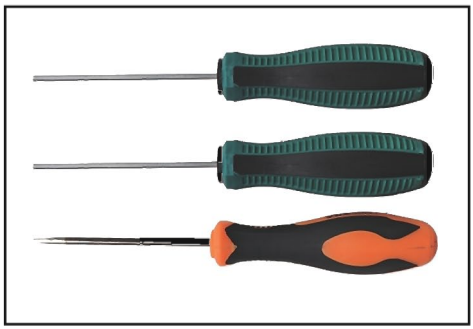
Dry box storage rack×1

Kit Contents



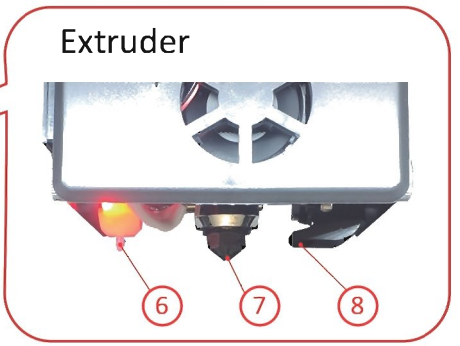
Drying box bearings×2

Desiccant



Screw Diver×3

Getting To Know Your 3D Printer



1. Switch
2. USB port
3. Magnetic PEI board
4. Build platform
5. Display screen
6. Automatic leveling device
7. Nozzle
8. Air outlet
9. PTFE tube channel cover
10. Sealing tape
11. Dry box
12. Dry box storage rack
13. Air filter
14. Power switch
15. Power cord port
16. Network port

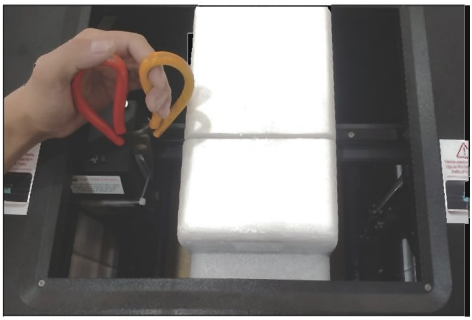
Unpacking Guide

1. Place the box on the floor with a clean flat surface.Open the box.

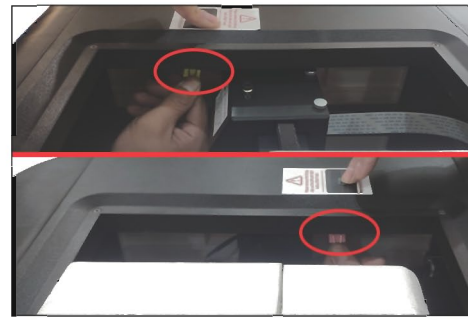
2. Move out the foam, take out the accessories.

3. Pull out the printer.

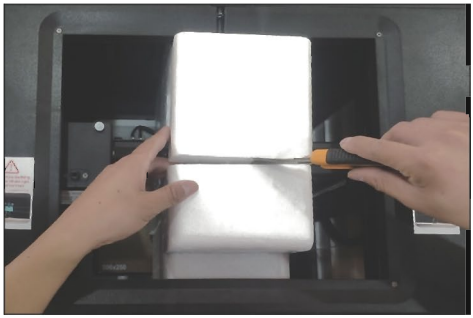
4. Remove the packing material.



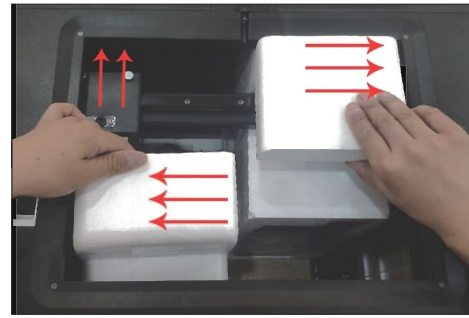
5. Cut off the plastic tie on extruder.



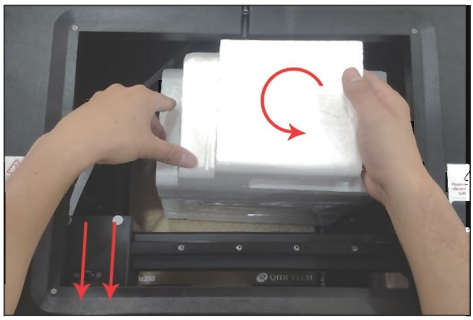
6. Remove the belt fixing clips on both sides of the Y-axis.



7. Separate the two pieces of foam in the middle.



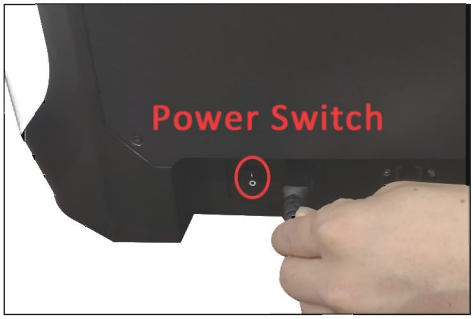
8. First move the extruder in the direction of the arrow to the picture position,then move out the foam.



9. First move the extruder in the direction of the arrow to the picture position,then rotate and move out the foam.

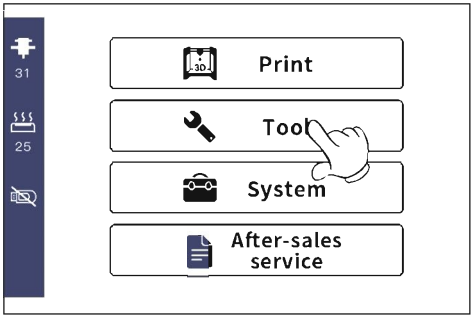
Note: This foam contains drying box components.

10. Take out the power cord.

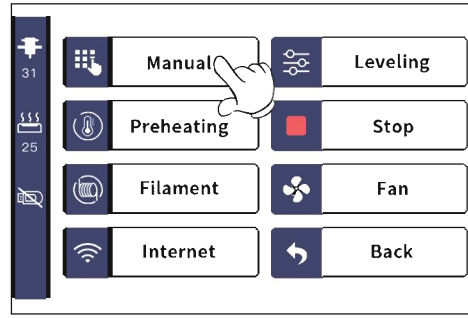


11. Plug in the power cord at the back of the 3d printer's lower left corner, then turn on the power.

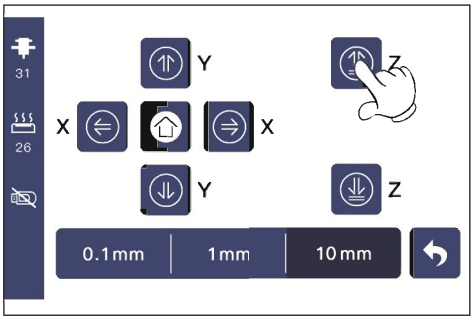
12. Click the button to turn on the 3d printer.



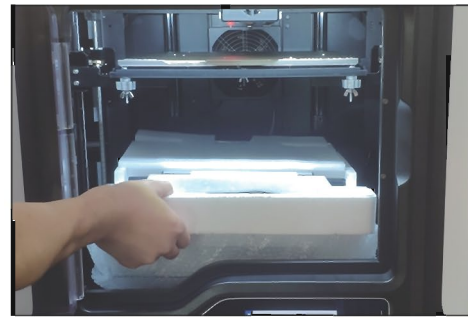
13. Click the ”Tool” icon .



14. Click the ”Manual” icon.



15. Click the” ”icon,until the platform rises to a suitable position.



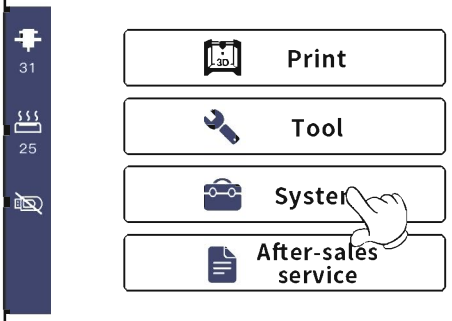
16. Take out the foam from the bottom of build platform.

17. Take out the top cover .

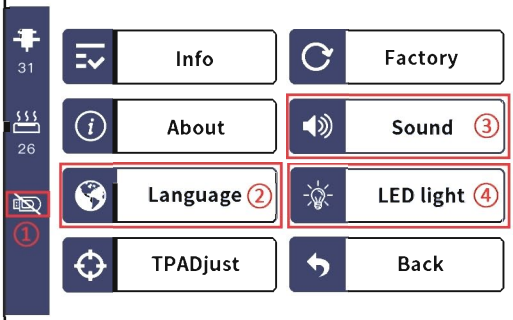
18. Take out the filament at the bottom of the carton.

19. Congratulations! You’ve finished the unpacking process. (Tip: Save your printer packaging for future transportation and storage.)

Display screen operator interface

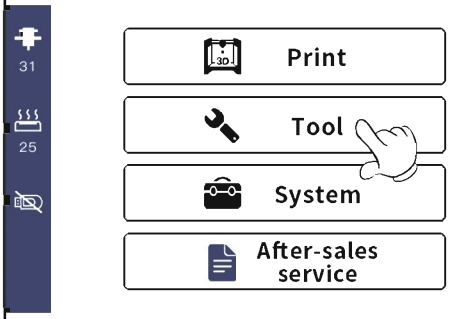


a. Click “ System ” icon.

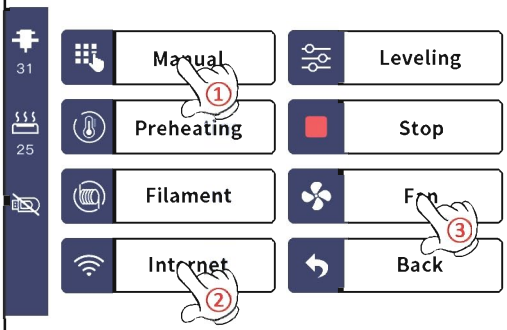


① USB Flash Drive Status : USB flash drive status is inserted or removed.
② Language : Multiple languages are available.
③ Sound : The sounds can be adjusted.
④ LED Light : The LED light can be turned on / turned off.

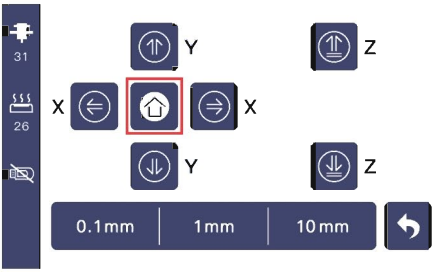
Display screen operator interface



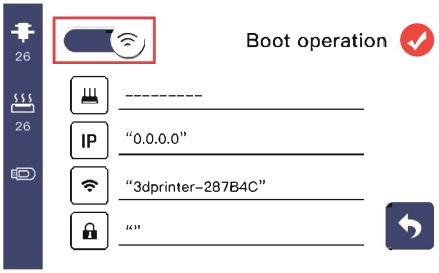
b. Click “ Tool ” icon.



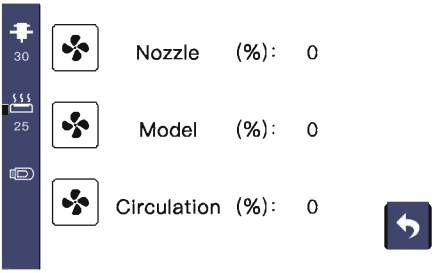
① Manual: User can move the X,Y,Z axis separately, click the “house” icon which on the center, the axis will move to home position.



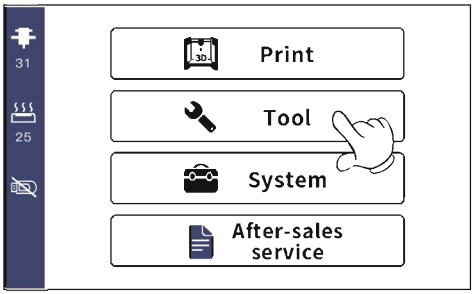
② Internet: Click on this icon,the network and Wi-Fi setting can be opened.



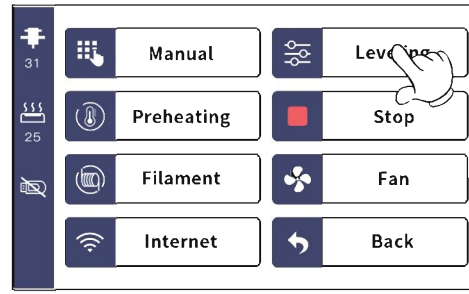
③ Click the icon to check if the four fans work properly.



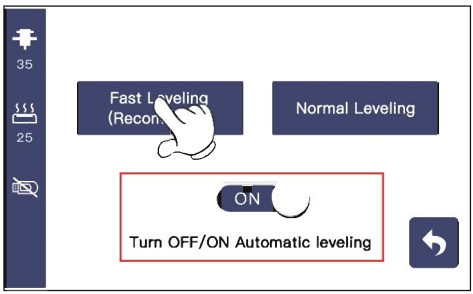
Adjust the build



1. Click the ”Tool” icon.

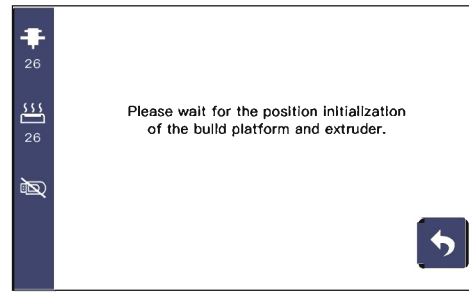


2. Click the ”Leveling” icon.



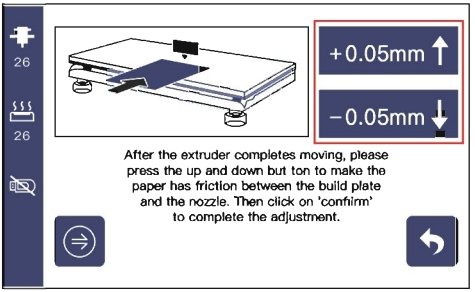
3. Highly recommend to click the fast leveling at the first time.
Whether the automatic leveling mode is turned on. (When the button is on the right side, it is on)

4. Confirm that there is nothing on the nozzle, click Next.



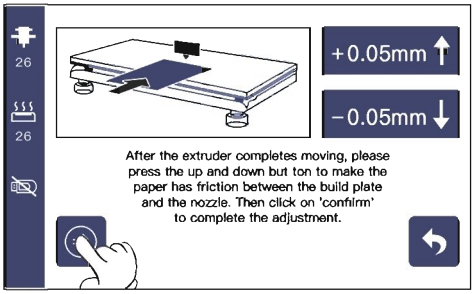
5. Awaiting the platform and extruder to reset.

Adjust the build

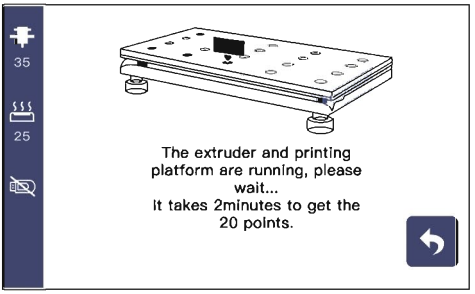

26
26
+0.05mm
−0.05mm
After the extruder completes moving, please press the up and down but ton to make the paper has friction between the build plate and the nozzle. Then click on 'confirm' to complete the adjustment.

6.Please press the up and down button on right side of the screen to adjust the distance between the nozzle and build plate.

Caution: The best printing distance is you can feel the friction when you move the leveling paper between the nozzle and build plate.

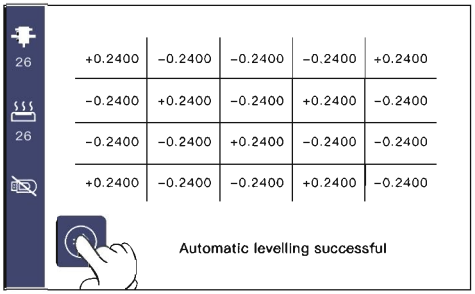

26
26
+0.05mm
−0.05mm
After the extruder completes moving, please press the up and down but ton to make the paper has friction between the build plate and the nozzle. Then click on 'confirm' to complete the adjustment.

7. Click Next.



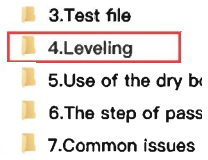
8. Wait for the extruder to collect 20 points.

Caution： When the error value between the collection points is too large, it will lead to the leveling failed. Suggest to click Next to return to the leveling selection interface and select normal leveling.



9. Click Next to return to the tool interface.

If in doubt, check out the videos and instructions in folder 4.

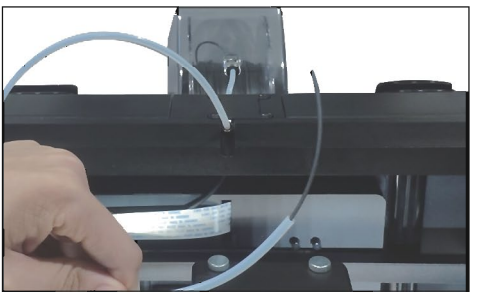


Filament mounting and filament loading

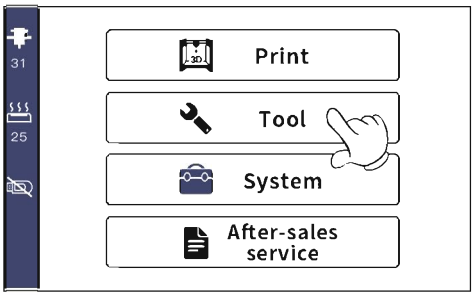
1. Open the drying box, Install the drying box bearing, then put in the desiccant.

2. Place the tube in the centre hole of the filament, then put the filament into the drying box, pass the filament through the quick connector on the drying box, and then put on the sealing tape.

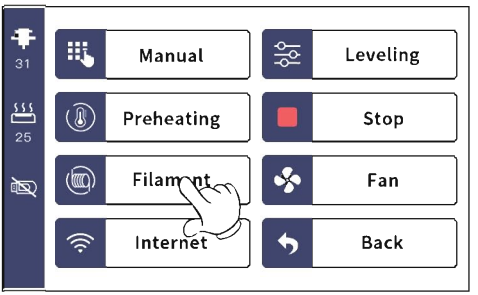
3. Install the dry box storage rack.



4. The filament are sleeved into the longest teflon tube, passed through the PTFE tube channel cover and placed in the dry box.

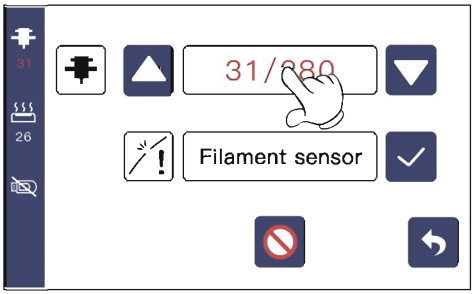


5. Click the ”Tool” icon.

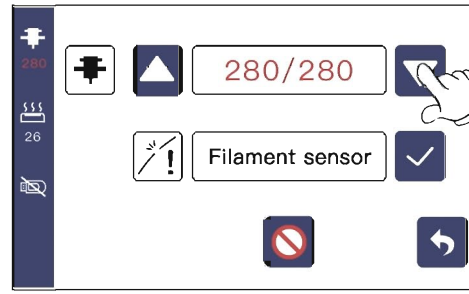


6. Click the ”Loading filament” icon.

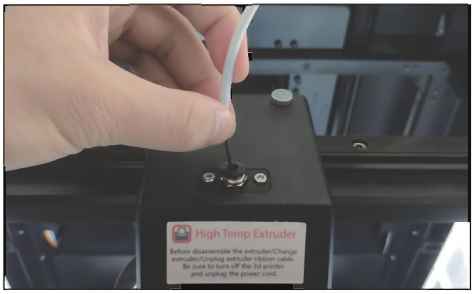
Filament mounting and filament loading



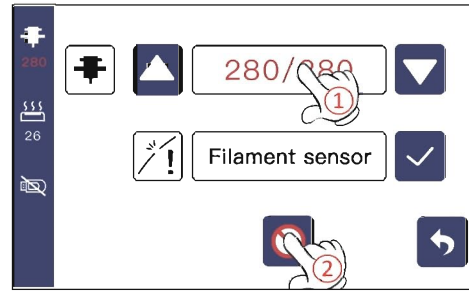
7. Click on the number, when the color changes to red, it shows that the temperature is rising.



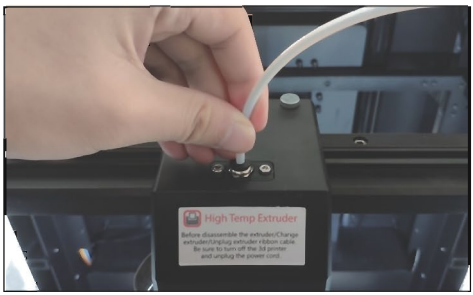
8. When the temperature reaches to 280℃, click the" ▼ "icon.



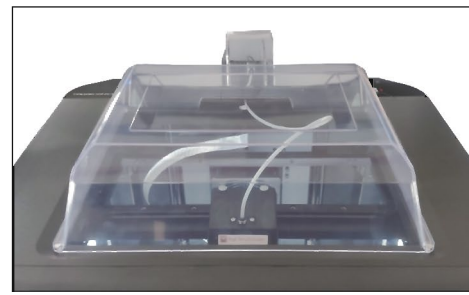
9. Pass the filament into the quick interface on the extruder, until the nozzle flows out.



10. Click on the number to stop heating,click the" ⊘ "icon.

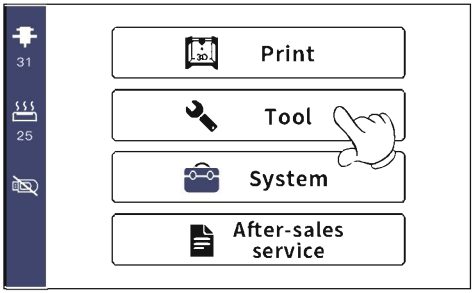


11. Insert the long PTFE tube into the quick interface and fix it.

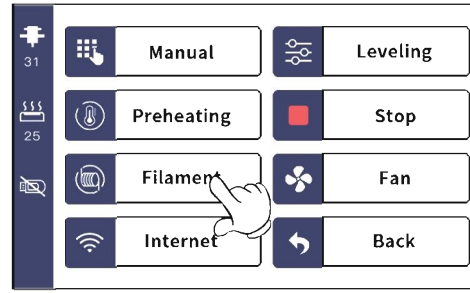


12. Close the top cover to complete the installation.

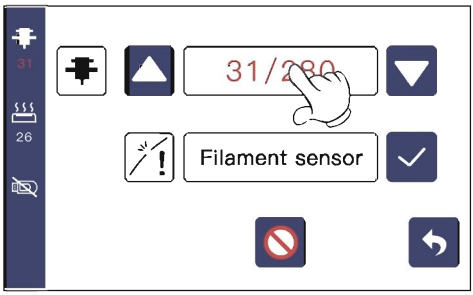
Unload the filament



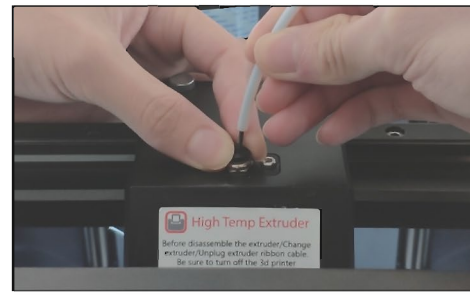
1. Click the ”Tool” icon.



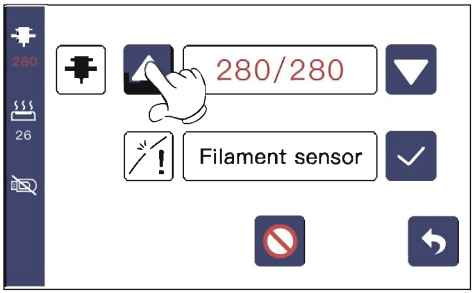
2. Click the ”Loading filament” icon.



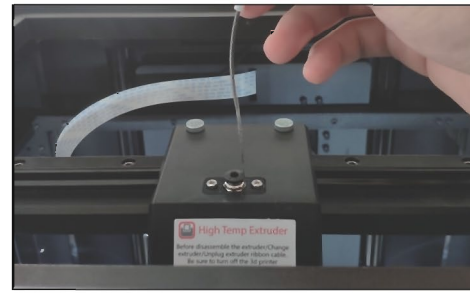
3. Click on the number, when the color changes to red, it shows that the temperature is rising.



4. Press and hold the plastic interface on the quick connector and pull out the PTFE tube.



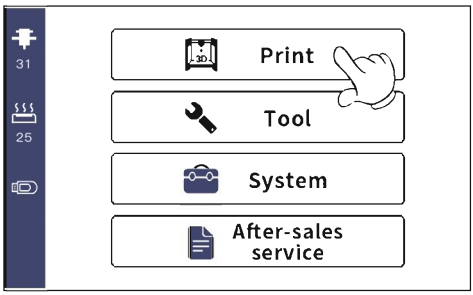
5. When the temperature reaches to 280℃, click the” ▲ ”icon.
Caution： filament will be squeezed down a little, then it will start to withdraw upwards.



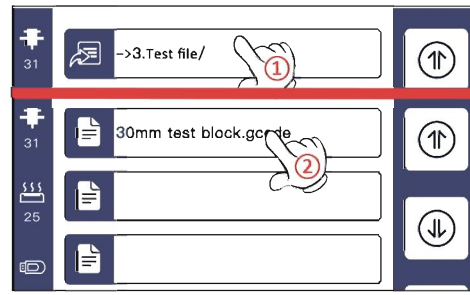
6. Take out the filament.

First printing

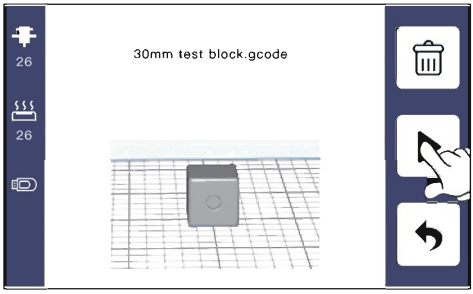
After finished leveling the build platform and loaded the filament, the user can print the test file "30mm test block.gcode".



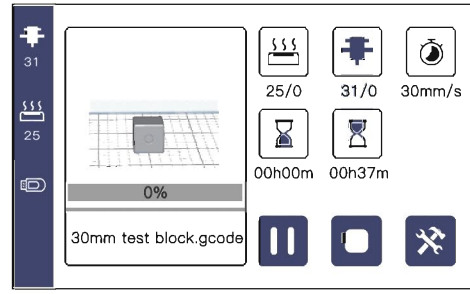
1. Click " Print " icon.



2. Find the "30mm test block.gcode" file and click on it to enter into the print screen.

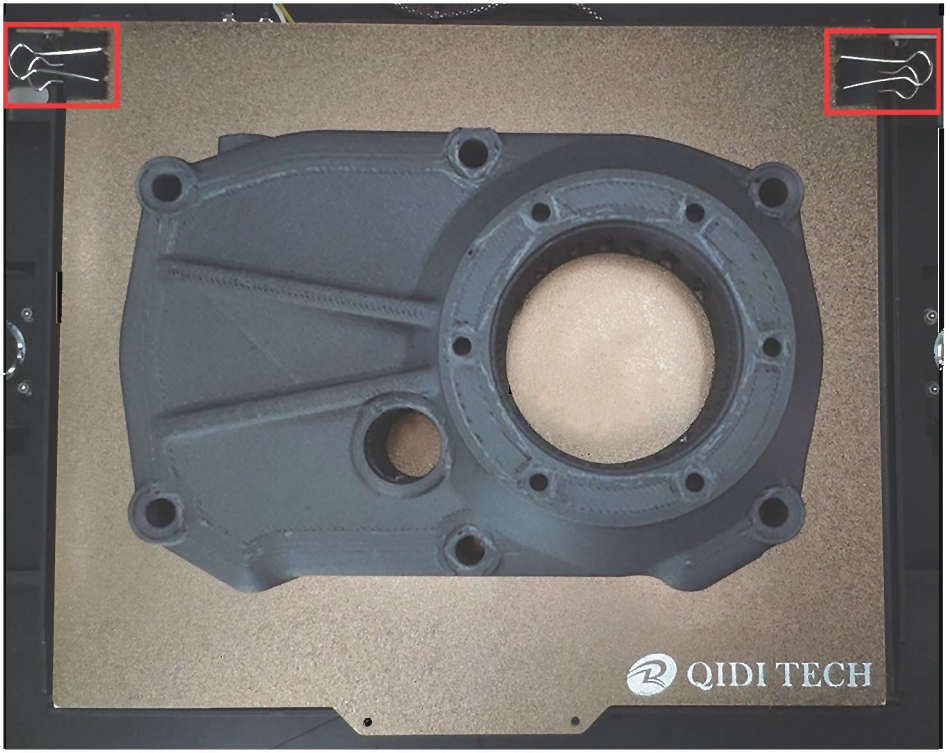


3. Click " ▶ " icon, start to print.



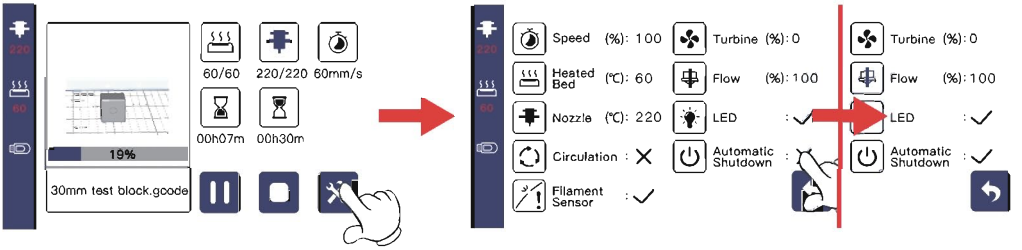
4. In the pop-up interface, user can see the progress.

Friendly Reminder : when printing the large size model, the thermal barrier shrinkage of the model may cause the build plate to warp up,please use the clips.



Automatic shutdown after printing

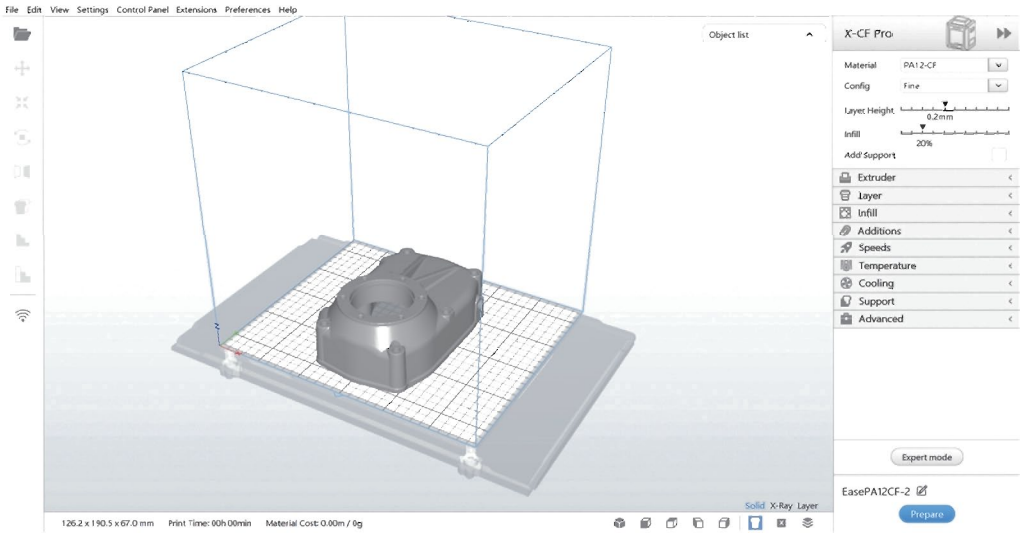
Click on the settings icon in the lower right corner when the model starts printing, then click ”Automatic Shutdown” icon, when'✕'change to '✓' , setup complete.



X-CF Pro

Slicer operation process

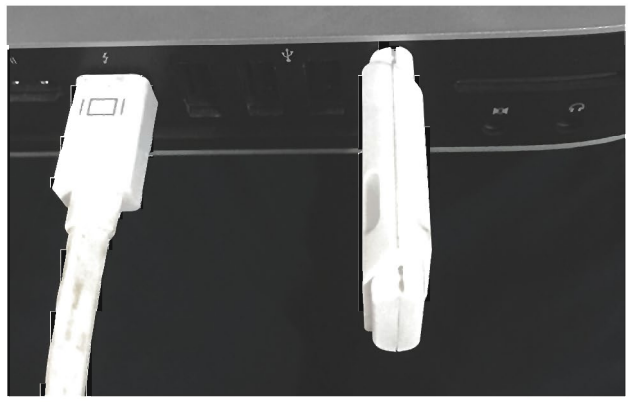
NOTICE: QidiPrint slicer does not support X-CF Pro printing via USB cable,support ethernet connection printing.



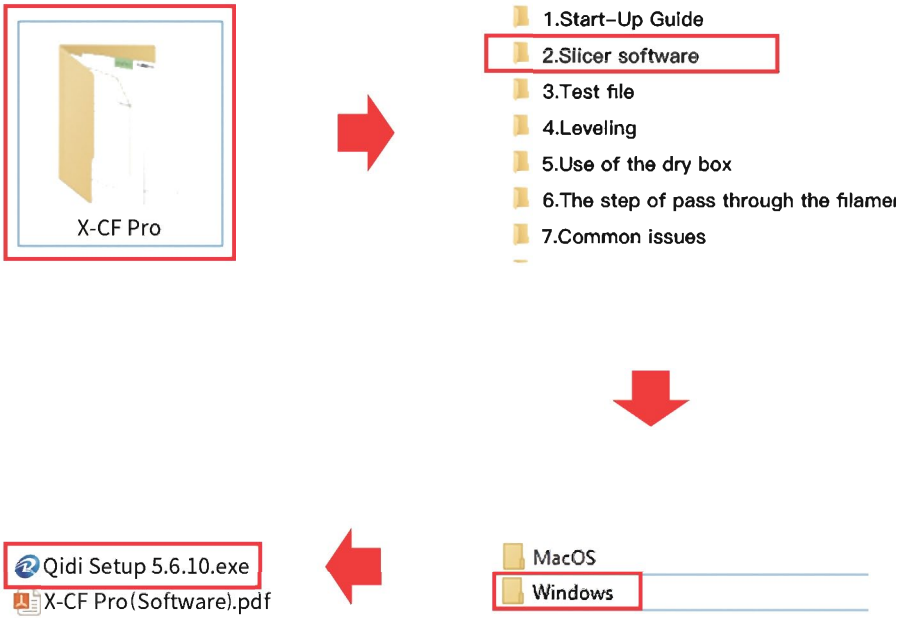
For Windows users

Slicer install

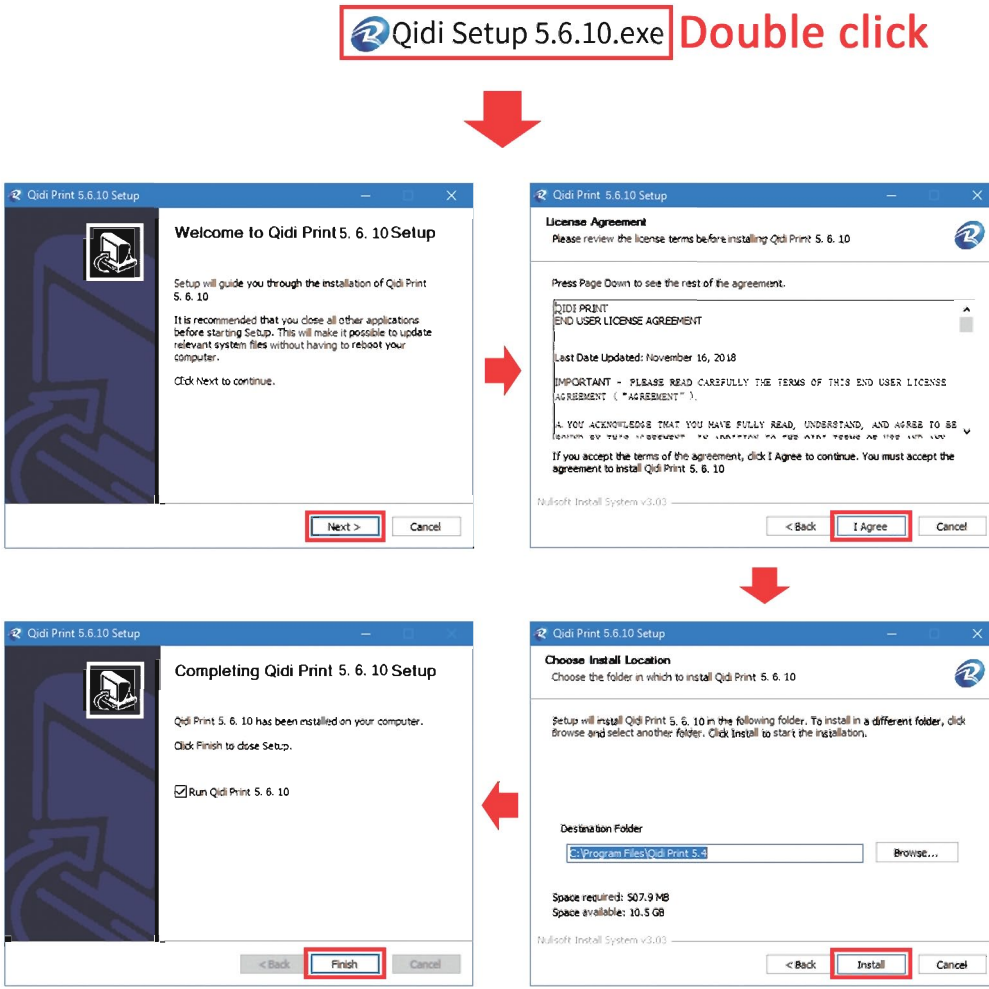
① Insert the USB flash drive into the computer.



② Create a new folder on the computer desktop, copy the USB flash drive software to the new folder.



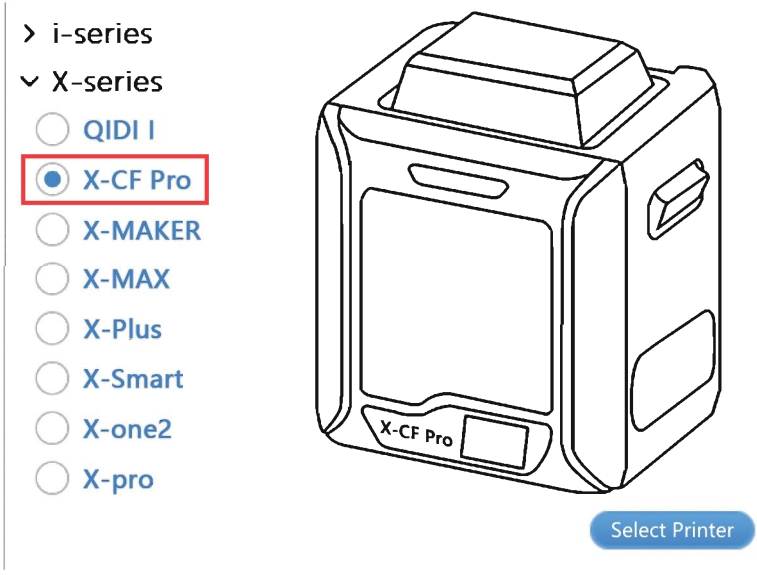
③ Double click to run the installer, install the software as below pictures.


Qidi Setup 5.6.10.exe
Double click
Qidi Print 5.6.10 Setup
Welcome to Qidi Print 5. 6. 10 Setup
Setup will guide you through the installation of Qidi Print 5. 6. 10
It is recommended that you close all other applications before starting Setup. This will make it possible to update relevant system files without having to reboot your computer.
Click Next to continue.
Next >
Cancel
Qidi Print 5.6.10 Setup
License Agreement
Please review the license terms before installing Qidi Print 5. 6. 10
Press Page Down to see the rest of the agreement.
QIDI PRINT
END USER LICENSE AGREEMENT
Last Date Updated: November 16, 2018
IMPORTANT - PLEASE READ CAREFULLY THE TERMS OF THIS END USER LICENSE AGREEMENT ("AGREEMENT").
BY YOU ACKNOWLEDGE THAT YOU HAVE FULLY READ, UNDERSTAND, AND AGREE TO BE
If you accept the terms of the agreement, click I Agree to continue. You must accept the agreement to install Qidi Print 5. 6. 10
Nullsoft Install System v3.03
< Back
I Agree
Cancel
Qidi Print 5.6.10 Setup
Completing Qidi Print 5. 6. 10 Setup
Qidi Print 5. 6. 10 has been installed on your computer.
Click Finish to close Setup.
Run Qidi Print 5. 6. 10
< Back
Finish
Cancel
Qidi Print 5.6.10 Setup
Choose Install Location
Choose the folder in which to install Qidi Print 5. 6. 10
Setup will install Qidi Print 5. 6. 10 in the following folder. To install in a different folder, click Browse and select another folder. Click Install to start the installation.
Destination Folder
C:\Program Files\Qidi Print 5.4
Browse...
Space required: 507.9 MB
Space available: 10.5 GB
Nullsoft Install System v3.03
< Back
Install
Cancel

Please click on the desktop shortcut to open the slicer.

Choose the printer type “X-CF Pro” .

Double click



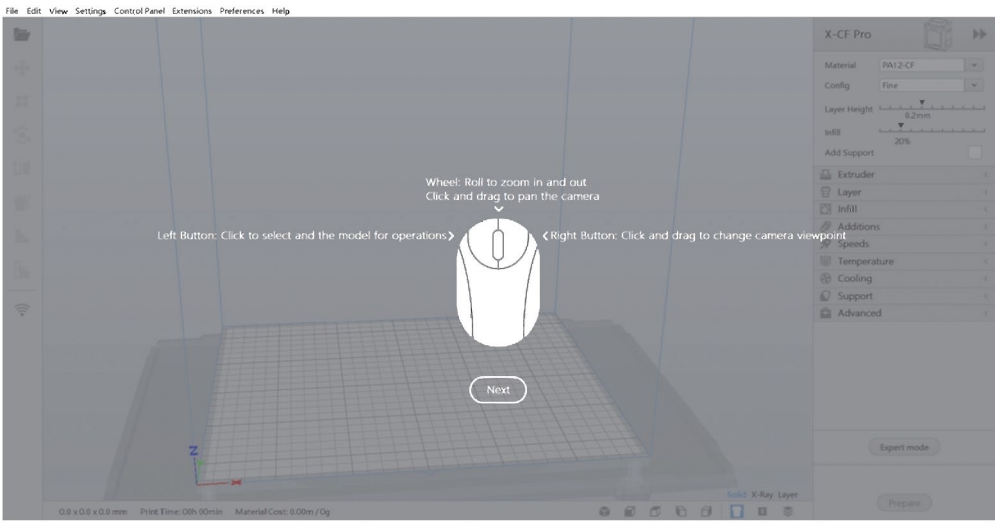
（A）Introduction of Mouse Function

Left Button: Click to select and the model for operations.

Wheel: Roll to zoom in and out

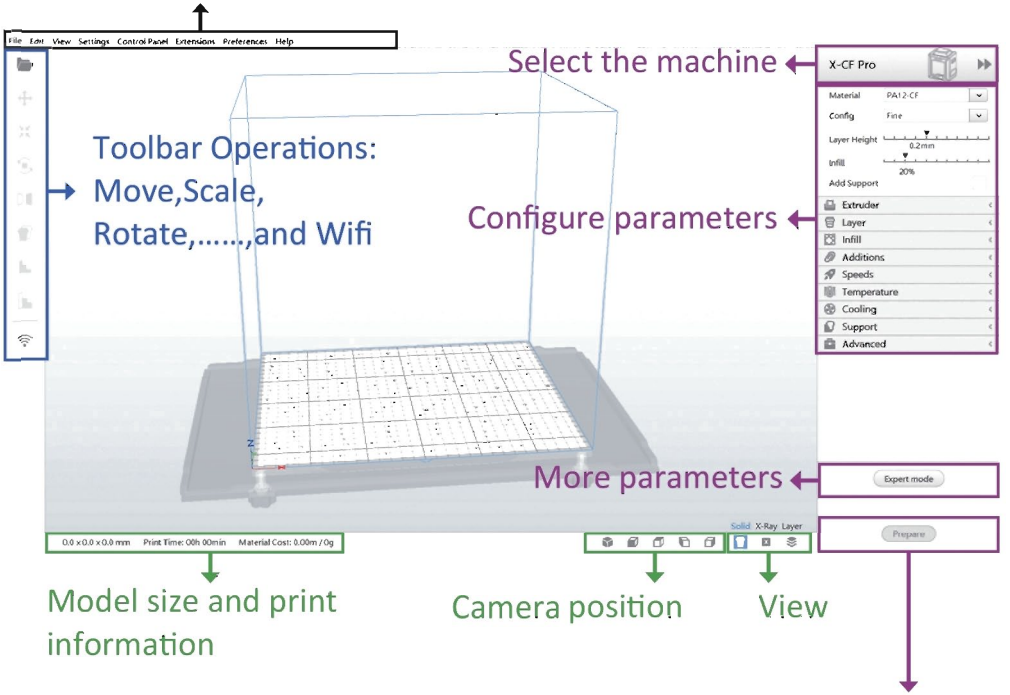
Click and drag to pan the camera.

Right Button: Click and drag to change camera viewpoint.



（B）Icon function introduction

Menubar: Includes Control Panel,
Configure Qidi,First Run Wizard,
Factory setting……



(C) First print

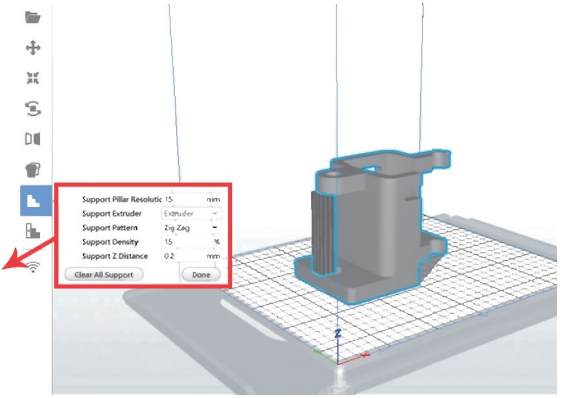
① Select your print type.
② Select your material type.
③ Select your printing precision(layer height).
④ Select an infill density.
⑤ Click the checkbox to enable print support.
⑥ Click prepare to slice your model.
⑦ Save the file or use Wifi to send the file.

（D）Addition Feature Instruction

1. Adding the support manually

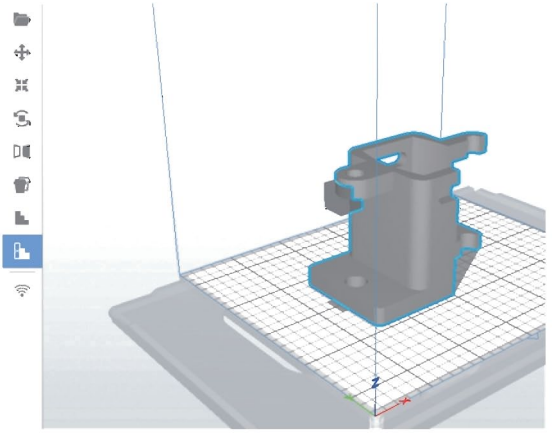
The operation of adding the support manually. First, please click the model, and add support tools manually in the toolbar on the right side of the main interface .

Here you can set the basic parameter for support (including the support size, support type, support density), then click on the model to add support part where you want to add on the model.Then click the done.

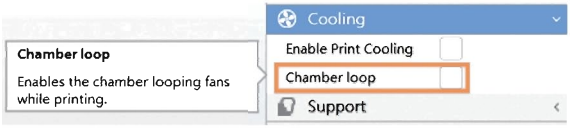


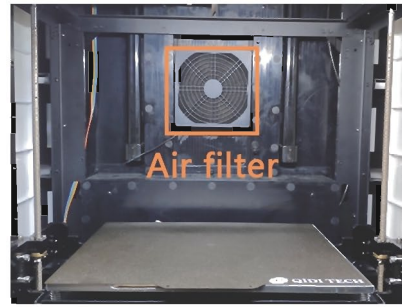
2. Support Blocker

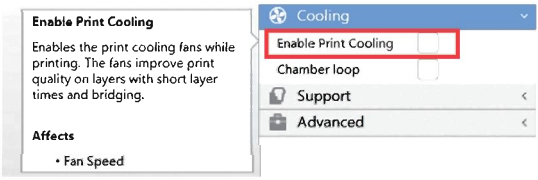
Cick the model then click the support blocker ,click on the part of the model that does not need the support, and the support will not be automatically added to this part.

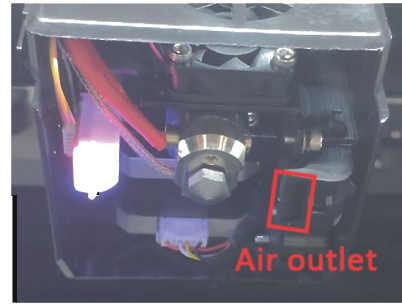


3. The function of the fan

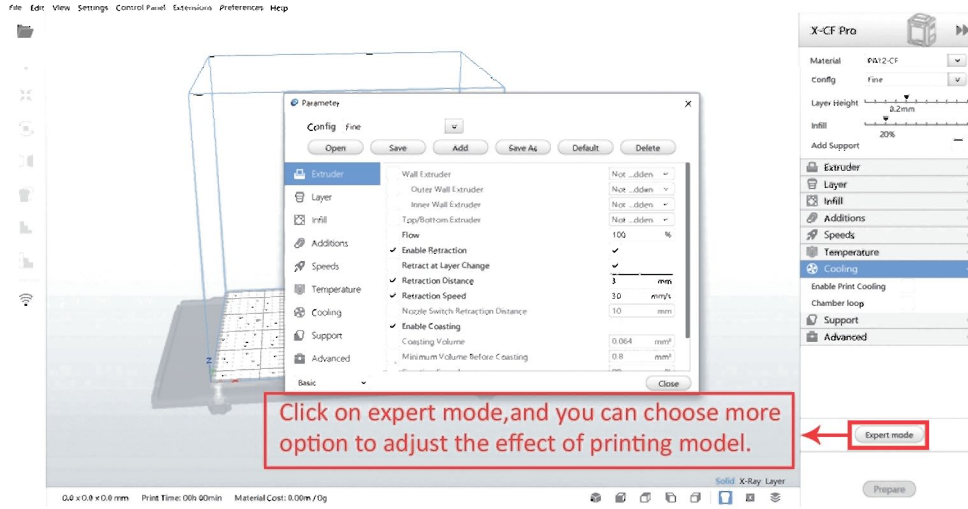






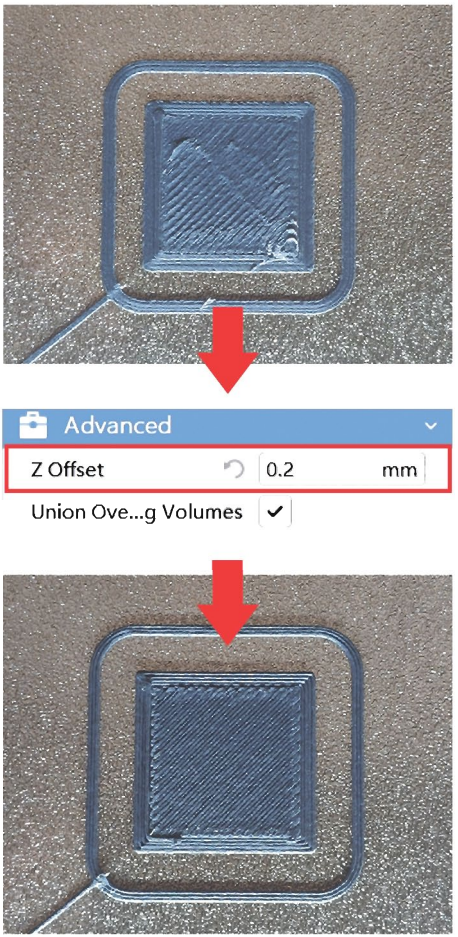


4. Expert model

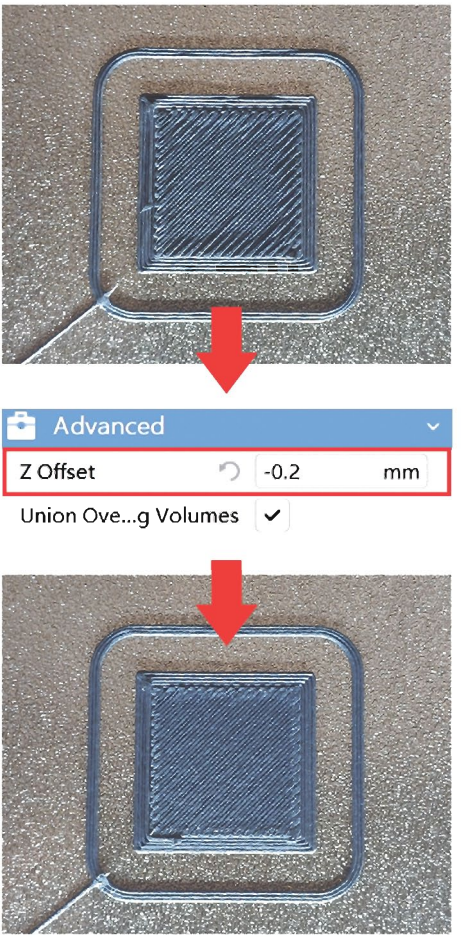


5. Z-axis shifting

The extruder is too close to the platform,resulting in printing failure. Set Z offset 0.2 to increase the distance between the extruder and the platform by 0.2mm.

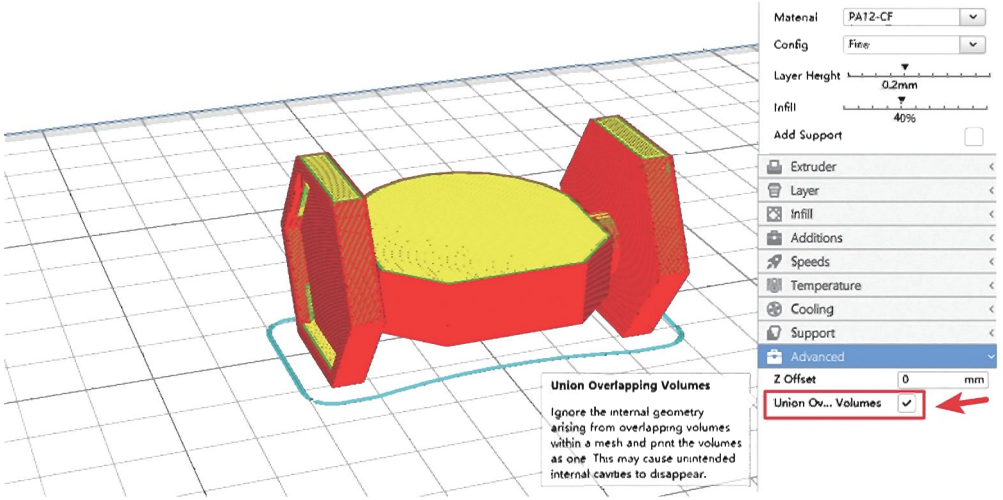


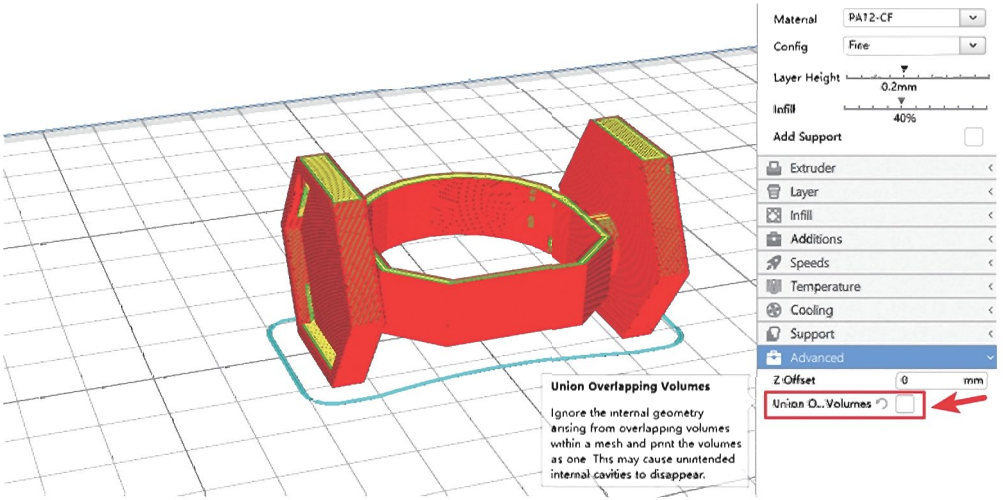
The extruder is too far to the platform,resulting in printing failure. Set Z offset -0.2 to reduce the distance between the extruder and the platform by 0.2mm.



6. Union overlapping volumes

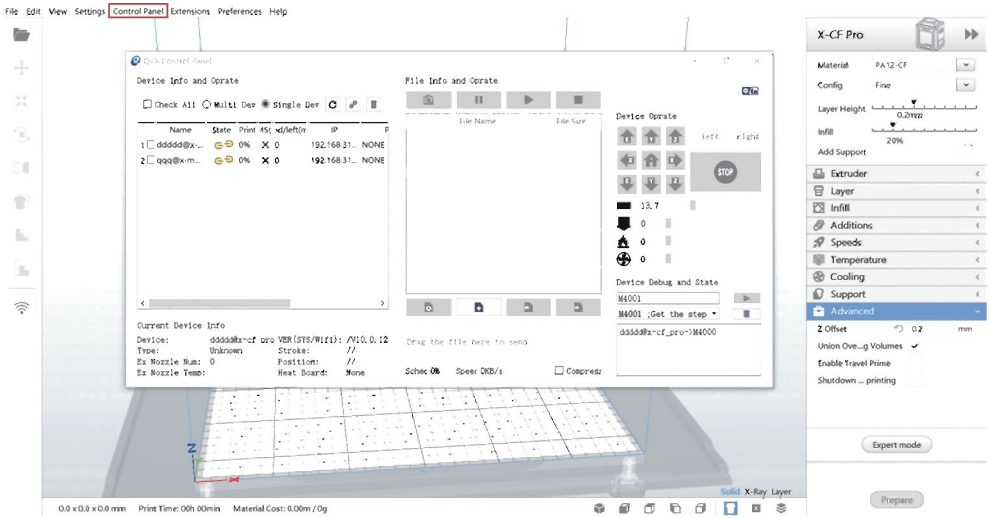
Some models are actually hollow inside, but they will be solid when printed out, so you need to cancel this setting manually.





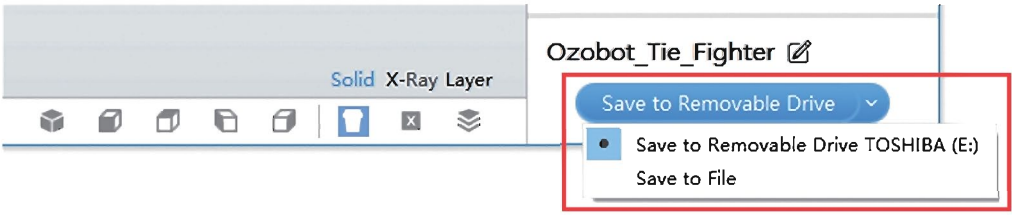
7. Control Panel

You can remotely control the printer and view the current status of the printer.

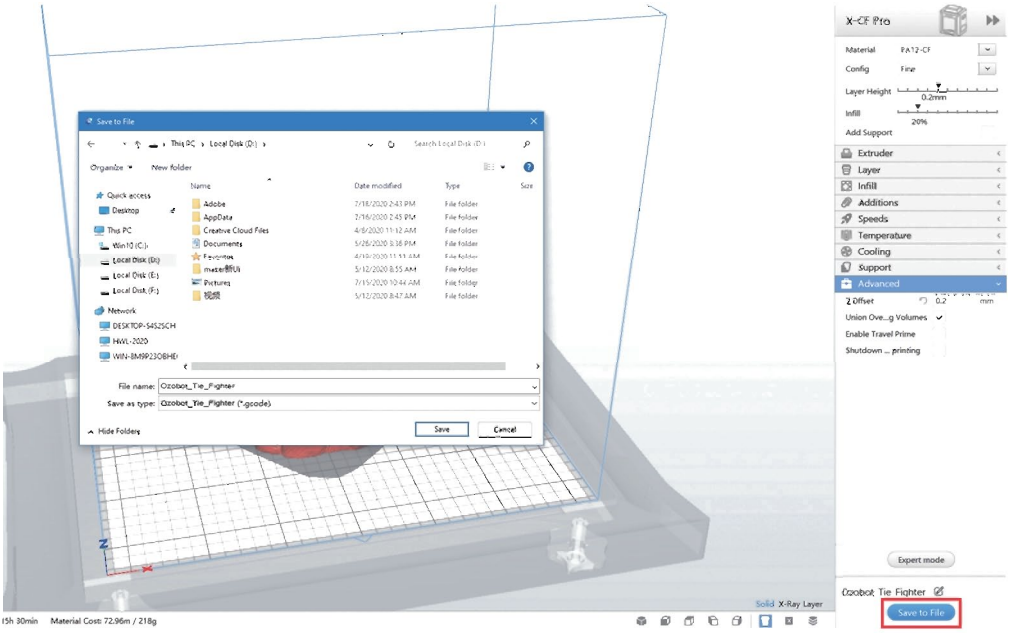


Save the gcode file

Method 1: When the USB flash drive is inserted into the computer, the gcode file can be save to the USB flash drive or the computer.

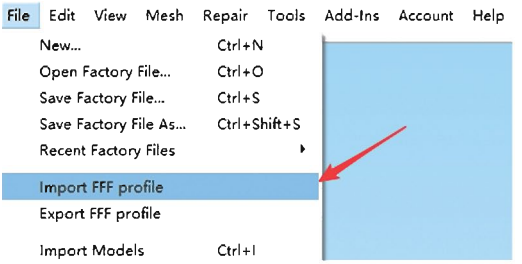


Method 2 : When the USB flash drive isn't inserted into the computer, the gcode file can be saved to the computer.

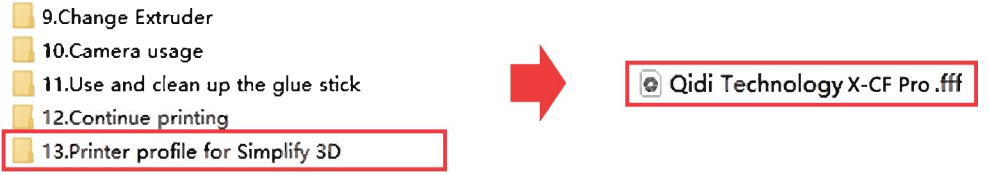


Adding printer profile for simplify 3D

1. Open Simplify3D, select “import FFF profile” in the File section.



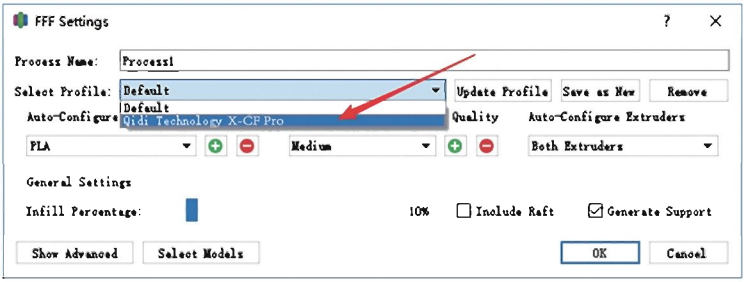
2. Import the X-CF Pro printer profile for Simplify 3D from the USB flash drive that we provided.



3. The message pops up when import successful.

Import Successful
The following profiles have been successfully imported and are now available from the profile drop-down list:
Qidi Technology X-CF Pro
OK

4. Open the FFF setting, choose “Qidi Technology X-CF Pro” that we just added in the select profile section.



FCC Statement

This equipment has been tested and found to comply with the limits for a Class B digital device, pursuant to Part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference in a residential installation. This equipment generates uses and can radiate radio frequency energy and, if not installed and used in accordance with the instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the user is encouraged to try to correct the interference by one or more of the following measures:

-- Reorient or relocate the receiving antenna.

-- Increase the separation between the equipment and receiver.

-- Connect the equipment into an outlet on a circuit different from that to which the receiver is connected.

-- Consult the dealer or an experienced radio/TV technician for help.

This device complies with part 15 of the FCC Rules. Operation is subject to the following two conditions: (1) This device may not cause harmful interference, and (2) this device must accept any interference received, including interference that may cause undesired operation.

Changes or modifications not expressly approved by the party responsible for compliance could void the user's authority to operate the equipment.

This equipment complies with FCC radiation exposure limits set forth for an uncontrolled environment. This equipment should be installed and operated with minimum distance 20cm between the radiator & your body.

Thank you!